

# APPENDIX F

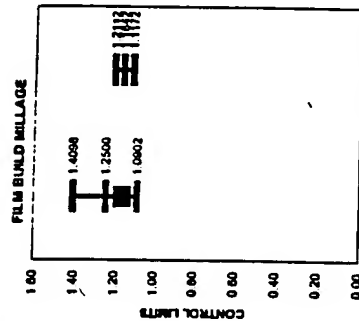
## Film Build Cpk's Cost Impact Analysis

### 1ST PREMISE

- VARIATION SELECTION**
- 1) Choose Variability
  - 2) Select First Target Range
  - 3) Average Adjusted to World Class Standard

Coating: Black Prime	Coating Min. Spec.: 0.9
Panel: Hood	Actual Average: 1.25
Booth: na	Actual Range: 0.68
	Actual Cpk: 0.587
	Subgroup Size: 14
	Target Range: 0.2
	World Class Cpk: 1.5
<b>Effect on Coating Usage -8.87%</b>	

Approximate Annualized Cost Impact  
\$ (3,754.55)



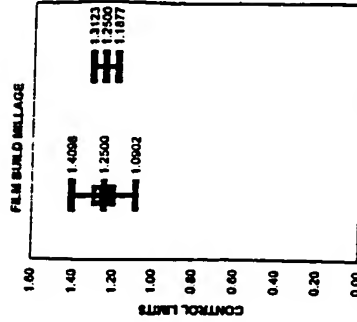
Within World Class - UCL - LCL - Average

### 3RD PREMISE

- VARIATION REDUCTION**
- 1) Variability Adjusted to World Class Standard
  - 2) Coating Usage Remains Constant
  - 3) Average Remains Constant

Coating: Black Prime	Coating Min. Spec.: 0.9
Panel: Hood	Actual Average: 1.25
Booth: na	Actual Range: 0.68
	Actual Cpk: 0.587
	Subgroup Size: 14
	New Range: 0.27
	World Class Cpk: 1.5
<b>Effect on Coating Usage 0.00%</b>	

Approximate Annualized Cost Impact  
\$ nil



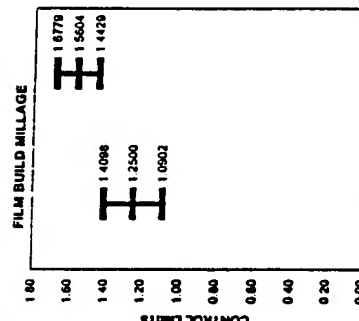
Within World Class - UCL - LCL - Average

### 2ND PREMISE

- VARIATION SELECTION**
- 1) Choose Variability
  - 2) Select Second Target Range
  - 3) Average Adjusted to World Class Standard

Coating: Black Prime	Coating Min. Spec.: 0.9
Panel: Hood	Actual Average: 1.25
Booth: na	Actual Range: 0.68
	Actual Cpk: 0.587
	Subgroup Size: 14
	Target Range: 0.5
	World Class Cpk: 1.5
<b>Effect on Coating Usage 24.83%</b>	

Approximate Annualized Cost Impact  
\$ 13,577.12



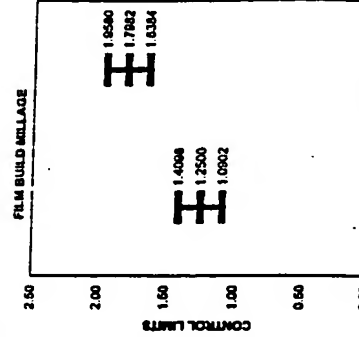
Within World Class - UCL - LCL - Average

### 4TH PREMISE

- INCREASED MILLAGE**
- 1) Coating Usage Increases
  - 2) Variability Remains Constant
  - 3) Average Adjusted to World Class Standard

Coating: Black Prime	Coating Min. Spec.: 0.9
Panel: Hood	Actual Average: 1.25
Booth: na	Actual Range: 0.68
	Actual Cpk: 0.587
	Subgroup Size: 14
	New Average: 1.7982
	World Class Cpk: 1.5
<b>Effect on Coating Usage 43.85%</b>	

Approximate Annualized Cost Impact  
\$ 23,976.12



Within World Class - UCL - LCL - Average

Cost per Unit Factors:				
Coating: Black Prime	Panel: Hood	Usage per Unit (gal.): 0.27	Coating Popularity %: 25	Booth % Flow: 100
		Cost per Gallon (\$): 27		Annualized Production (units) 200,000

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